

10/11/2008 3:34:46 PM

Process Sheet

Line Number	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CAP		
P.O. Number	: 43288		Part Number	: D2965		
This Issue	: 10/11/2008 S.O. No. :		Drawing Number	: D2965 REV B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /		Drawing Revision	: B		
Previous Run	: 38605		Material	:		
Written By	:		Due Date	: 20/11/2008 Qty: 30 Um: Each		
Checked & Approved By	: <u>JLO 08.11.11</u>					
Comment	: Est: A 00.05.31 New Issue EC		Est Rev:Added Turning as per Rev B 06-12-15 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
<p>Comment: PURCHASING Issue P/O: <u>7552</u> <u>JLO 08.11.11</u> Cast per Dwg D2965 Material Release Note Required</p>		
2.0	D2965P	Cap
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) Cap</p>		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached</p>		
4.0	QC6	DIMENSIONAL CHECK
<p>Comment: DIMENSIONAL CHECK</p> <p><i>P. JLO/25 (30)</i></p>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill as per Dwg D2965 with DT8538 Deburr and Turn <i>136</i></p> <p><i>EP 08/12/09 (30)</i></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

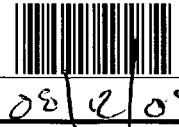
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 3:34:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: CAP
Job Number: 43288		Part Number: D2965
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC6	DIMENSIONAL CHECK 
Comment: DIMENSIONAL CHECK		 S 08/209 X20 center
7.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Mask as per Dwg D2965 Powder To match Skidtube(Ref: 4.3.5.x) as per QSI 005 4.3		 MT 08-12-09
START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		
9.0	ALS71032225	INSERT 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s) INSERT Pick: Qty Part Number Description Batch		
2 ALS7-1032-225 or AKS7-1032-225 or ALS4-1032-225 or AKS4-1032-225		
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Inserts as per Dwg D2965		
11.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 43288

Part Number: D2965

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP1

MF

08-12-11

30

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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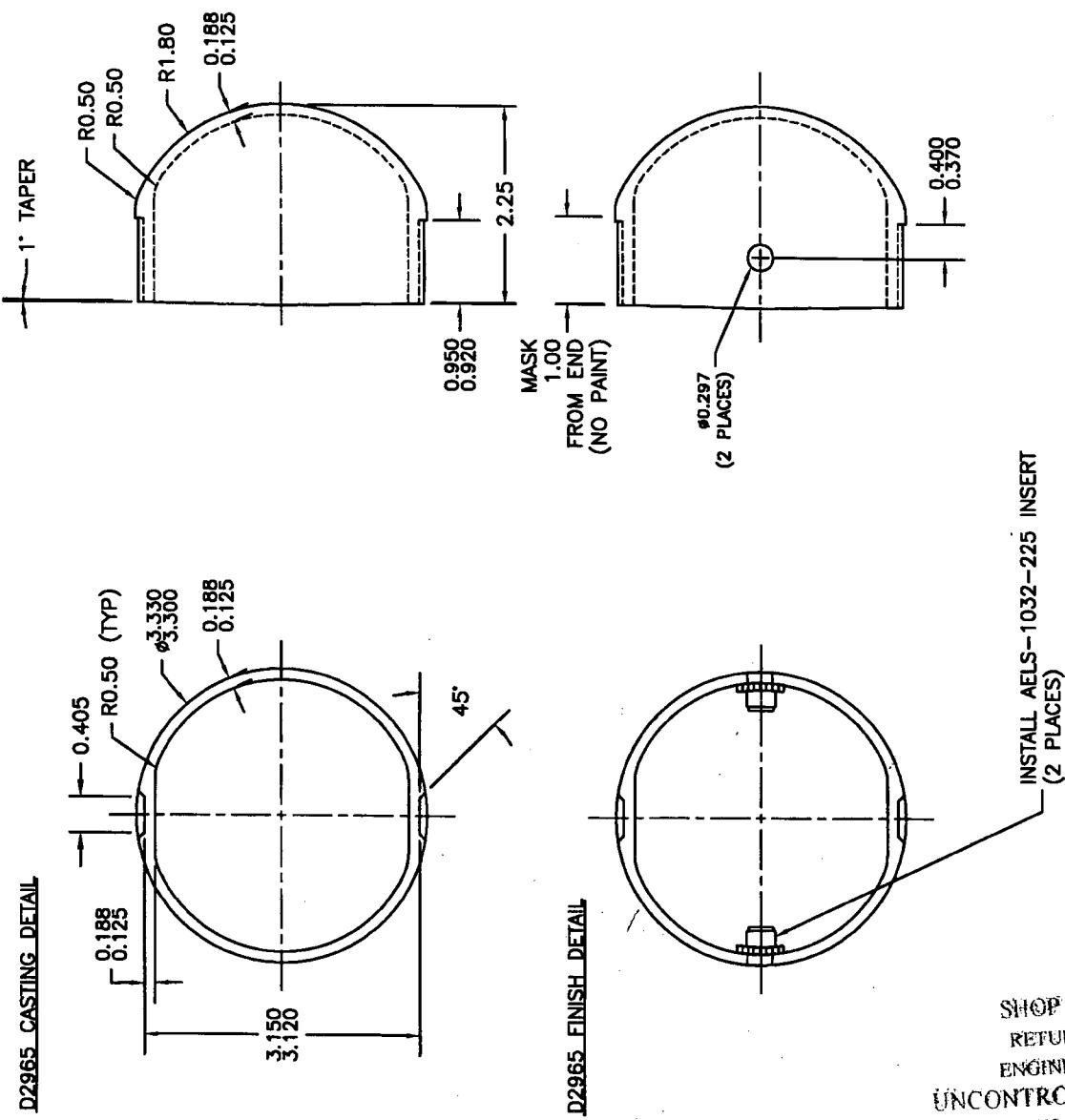
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2965
DATE		REV. B SHEET 1 OF 2
06.11.01		SCALE 1:2
A	00.02.24	NEW ISSUE
B	06.11.01	ADD -3 CAP

RELEASED

06.12.12



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43288

D2965 CAP
1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE INCHES

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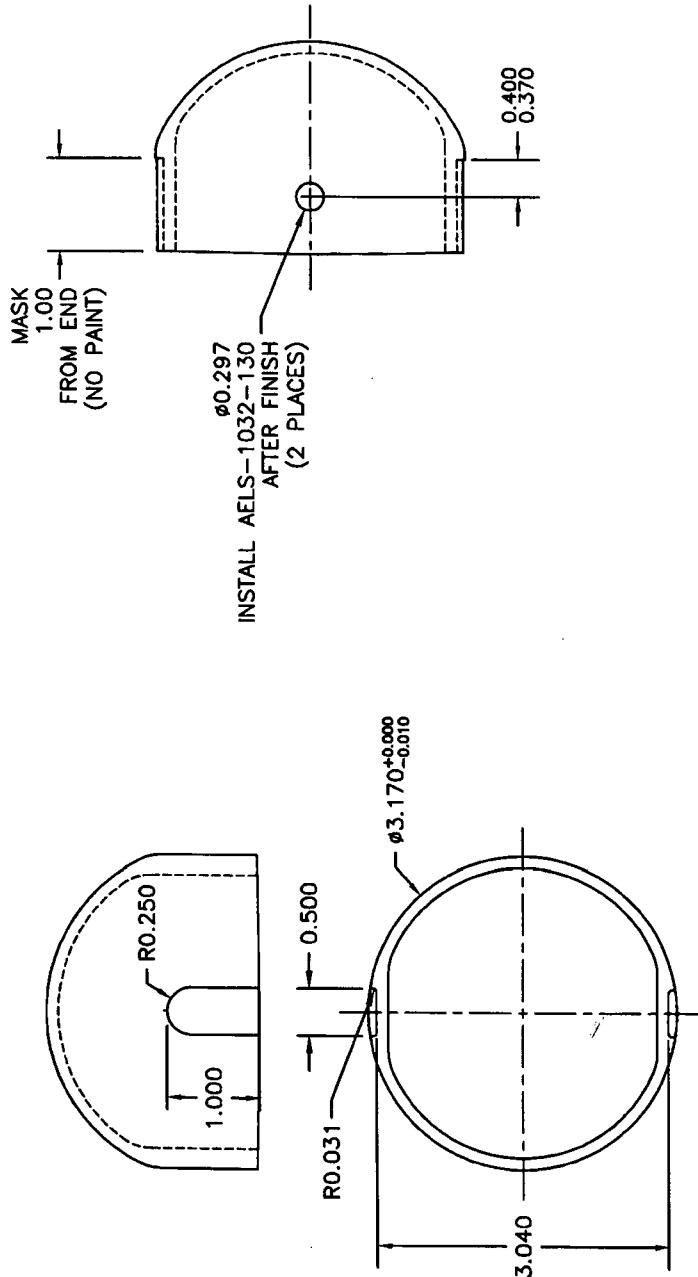
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2965
DATE		REV. B SHEET 2 OF 2
06.11.01		SCALE 1:2

RELEASED06.12.01 *[Signature]*D2965-3 FINISH DETAILD2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP
1) MATERIAL: MAKE FROM D2965 CAP
2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE INCHES

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WORK ORDER
NO. 43288

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NOTE: Date & initial all entries

Aluminum Foundry Ltd

714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448

Packing Slip

Packing Slip No.: 32830
Date: Nov 21, 2008
Page: 1

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7
Order No.: 7552	Sold By:
Shipped By: FEDEX	Ship Date: Nov 21, 2008
Tracking No.: 8491 8012 0924	

Item No.	Unit	Description	Quantity
Z200080	Each	D2965 CAP	30
Comment:			

7C CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-16 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à Shipped	DART AEROSPACE	A.F. & P.W. Série no./Serial no.
1270 Aberdeen Street		Packing Date: 31/10/2008 Slip No. 32830
Hawkesbury, ON, K6A 1K7		Votre No. Commande 00007278 Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
30	D 2965 CAP	2200080	A356.2	ingot#851118 <i>Salisbury</i>

Analyse Analysis (as in Ingots)	
(Si)	7.00%
(Fe)	0.06%
(Cu)	0.00%
(Mn)	0.00%
(Mg)	0.42%
(Zn)	<0.01%
(Ti)	0.16%

Donnée Yield :	Résistance à la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %
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Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per :

Coc-100

A. Vella